

LAMINATED TUBE AND MOLDED TUBE PRODUCTS  
COMPRISING THE LAMINATED TUBE

Technical Field

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This invention relates to the laminated tube having an outer layer laminated onto the substrate layer and to molded products using this laminated tube.

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Background art

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Conventionally, there are known those tubes of a laminated structure in which the outer layer is laminated onto the substrate layer. These laminated tubes usually have a structure in which the outer layer is laminated uniformly in the peripheral direction of the tube cross-section.

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The molded products of a laminated structure, in which an outer layer is laminated onto the substrate layer, are obtained by, for example, co-extruding two different types of synthetic resins or cladding the substrate layer with the second layer. In this cladding method, the substrate layer has already been made into a tube, and is clad with the second layer by an ordinary extrusion-molding process.

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On the other hand, the co-extrusion molding method utilizes a molding die that has two or more separate flow paths for the molten resins and lets these flow paths merge within the die. The molding die has such a cross-section that gives the shape of a resinous tube. Two types of resins are molten and run through the respective flow paths. The two layers are welded firmly to each other, and the laminated tube is extruded from the die exit in the cross-sectional shape of the die, and is left to cool.

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The laminated tubes made by conventional co-extrusion molding process has difficulty in preventing cuts in the outer layer to be laminated onto the substrate layer and also in cladding the outer layer in the uniform thickness because each synthetic resin has a different softening point and flow resistance.

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A technology for laminating the outer layer onto the substrate layer at a uniform thickness has been developed to solve this problem.

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5           In the cladding method, too, it is also difficult to clad the substrate layer with the outer layer at a uniform thickness because there is a pressure difference generated in the resin inside the head of the extrusion-molding die. In order for this problem to be solved, a technology has been developed to extrude the outer layer in a pipe shape from the molding die having a diameter  
10 larger than the outer diameter of the tubular substrate layer and to make the outer layer stick onto the substrate layer by sucking the outer layer from the nipple side of the die exit under reduced pressure.

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15           However, if the outer layer laminated onto the substrate layer has a uniform thickness, the tube looks even and monotonous and lacks spice, thus giving no decorative effect. Furthermore, the tube cannot be identified simply by touch.

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          Meanwhile, even in the case where the outer layer laminated onto the substrate layer has some irregularity in molding the laminated tube, it is necessary to produce the irregularity while maintaining certain uniformity if a high-class image is to be achieved in addition to aesthetic appearances.

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          Consequently, the technical problem of this invention is to laminate the outer layer onto the substrate layer that makes up the main body of the tube, wherein the outer layer has or consists of a projecting portion or portions while  
30 maintaining certain uniformity. The object of this invention is to provide the laminated tube and the molded tube products comprising the laminated tube, which show the decorative effect derived from the laminated outer layer and which enable the user to identify the tube by touch, too.

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### Disclosure of the Invention

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          The means of carrying out the invention of Claim 1 to solve the above-described technical problem exists in the configuration that the tube is  
40 laminated and that the outer layer laminated onto the substrate layer, which

makes up the main body of the tube, has or consists of a projecting portion disposed in the axial direction.

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5           In the invention of Claim 1, the outer layer having or consisting of a linear projecting portion in the axial direction is laminated onto the substrate layer that makes up the main body of the tube. The linear projecting portion on the outer surface of the tube gives the tube the decorative quality that makes the tube look attractive. It also becomes possible to distinguish the  
10 tube from other tubes simply by touching the projecting portion on the tube surface with fingers.

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          Even if a relatively soft outer-layer is disposed on the substrate layer,  
15 the thin wall of the tube deforms easily because of the difference in thickness between the projecting portion and the tube wall. Therefore, the main body of the tube can be easily pressed flat along the projecting portion on the outer layer. The tube contents can be easily squeezed out of the molded tube product made of this laminated tube.

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          The means of carrying out the invention of Claim 2 includes the invention of Claim 1, and also comprises that the substrate layer is flexible and that the outer layer is harder than the substrate layer.

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          In the invention of Claim 2, the substrate layer that makes up the main body of the tube has flexibility, and the outer layer having or consisting of the projecting portion to be laminated on the substrate layer is harder than the  
30 substrate layer. Therefore, this projecting portion serves as the backbone of the main body of the tube, and maintains the form of the tube stably.

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          The means of carrying out the invention of Claim 3 includes the  
35 configuration of the invention of Claim 1 or 2, and also comprises that the projecting portion is disposed linearly in the axial direction.

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          In the invention of Claim 3, there is provided the outer layer having or  
40 consisting of a linear projecting portion, which is laminated onto the main body

of the tube. The tube can be pressed flat along this projecting portion that acts as the backbone of the tube. Thus, the projecting portion serves as the guide when the tube is pressed flat.

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The means of carrying out the invention of Claim 4 includes the configuration of the invention of Claim 1, 2, or 3, and also comprises that plural projecting portions are provided.

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In the invention of Claim 4, plural projecting portions are formed in stripes on the main body of the tube. The stripes improve decorativeness of the tube. From the number of stripes determined for the tube, the user can distinguish the tube from other tubes simply by touch.

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The means of carrying out the invention of Claim 5 includes the configuration of the invention of Claim 1, 2, 3, or 4, and also comprises that the projecting portions are disposed axisymmetrically in the cross-sectional view.

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In the invention of Claim 5, the projecting portions are disposed axisymmetrically. The tube can be pressed flat along the axisymmetrical projecting portions, thus making it convenient for the tube bottom to be sealed when tubular containers or pouch containers are molded. As another advantage, the projecting portions serve as the guide to press and flatten the tubular container or pouch container so that the contents can be easily squeezed out of the tubular or pouch container made of this laminated tube.

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The means of carrying out the invention of Claim 6 exists in the configuration that the laminated tube of Claim 4 or 5 is provided with the projecting portions that have different widths.

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In the invention of Claim 6, the projecting portions having different widths make the tube look very attractive, and allow characters and the like to be printed on the wide types of projecting portions.

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The means of carrying out the invention of Claim 7 exists in the configuration that even-numbered projecting portions are disposed at equal intervals on the laminated tube of Claim 4 or 5.

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Because the projecting portions are disposed at equal intervals in the invention of Claim 7, a stripe pattern is formed over the entire tube surface, and the decorativeness of the tube is improved.

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The means of carrying out the invention of Claim 8 exists in the configuration that the projecting portions give a graded effect caused by the change in the thickness of the projecting portions disposed on the laminated tube of Claim 1, 2, 3, 4, 5, 6, or 7.

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In the invention of Claim 8, the laminated tube has the improved decorativeness because of the graded effect caused by the change in the thickness of the projecting portions.

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The means of carrying out the invention of Claim 9 exists in the configuration that an aluminum laminating material is used as the main body of the tube in the laminated tube of Claim 1, 2, 3, 4, 5, 6, 7, or 8.

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In the invention of Claim 9, the main body of the tube comprises an aluminum laminating material, and the outer layer having or consisting of a projecting portion or portions are laminated onto this material. The projecting portion or portions serving as the backbone reinforce the aluminum laminated tube, and also improves the decorativeness.

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The means of carrying out the invention of Claim 10 exists in the configuration that the substrate layer and the outer layer have different colors in the laminated tube of Claim 1, 2, 3, 4, 5, 6, 7, 8, or 9.

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In the invention of Claim 10, not only tube irregularity but also additional colors improve the decorativeness because the outer layer having or

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consisting of a projecting portion or portions in a different color is laminated onto the substrate layer.

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- 5           The means of carrying out the invention of Claim 11 exists in the configuration that the projecting portion or portions are disposed spirally on the surface of the laminated tube of Claim 1, 2, 3, 4, 5, 6, 7, 8, 9, or 10.

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- 10           The means of carrying out the invention of Claim 12 exists in the configuration that the projecting portion or portions have a wave form on the surface of the laminated tube of Claim 1, 2, 3, 4, 5, 6, 7, 8, 9, or 10.

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- 15           In the invention of Claim 11 or 12, the outer layer laminated on the substrate layer has or consists of a projecting portion or portions in a spiral or wave form, which looks attractive visually and improves decorativeness of the tube.

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          The means of carrying out the invention of Claim 13 exists in the configuration that each of the projecting portions has a different color in the invention of Claim 1, 2, 3, 4, 5, 6, 7, 8, 9, 10, 11, or 12.

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- In the invention of Claim 13, the decorativeness of the tube is improved because each projecting portion has a different color and because the projecting portions in attractive colors form a stripe or waveform pattern. For instance, all the projecting portions may have a different color, or two or three colors may be repeated alternately or for each group of three projecting portions. Plural colors may also be used at random for the projecting portions.

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- 35           The means of carrying out the invention of Claim 14 exists in the configuration that the laminated tube of Claim 1, 2, 3, 4, 5, 6, 7, 8, 9, 10, 11, 12, or 13 is cut to a predetermined length, with one end being flattened and sealed, and the other end being provided with a head portion comprising shoulder and neck.

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The means of carrying out the invention of Claim 15 exists in the configuration that the laminated tube of Claim 1, 2, 3, 4, 5, 6, 7, 8, 9, 10, 11, 12, or 13 is cut to a predetermined length and is molded into a tube product having both ends flattened and sealed.

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In the invention of Claim 14 or 15, the laminated tube with added decorativeness can be used to mold an elaborately designed tube products.

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### Brief Description of the Drawings

Fig. 1(a) is a partially cut, side elevational view, and Fig. 1(b) is a cross-sectional view, of the laminated tube in the first embodiment of this invention.

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Fig. 2 is a cross-sectional view showing another example of the laminated tube shown in Fig. 1.

Fig. 3 is a cross-sectional view showing an example of the co-extrusion molding die of this invention.

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Fig. 4 is a vertical section showing an example of the cladding die of this invention.

Fig. 5(a) is a partially cut, side elevational view, and Fig. 5(b) is a cross-sectional view, of the laminated tube in the second embodiment of this invention.

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Fig. 6 is a side elevational view of the tubular container made by using the laminated tube shown in Fig. 5.

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Fig. 7(a) is a partially cut, side elevational view, and Fig. 7(b) is a cross-sectional view, of the laminated tube in the third embodiment of this invention.

Fig. 8(a) is a partially cut, side elevational view, and Fig. 8(b) is a cross-sectional view, of the laminated tube in the fourth embodiment of this invention.

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Fig. 9(a) is a side elevational view, and Fig. 9(b) is a cross-sectional view, of the tubular container using the laminated tube in the fifth embodiment of this invention.

Fig. 10 is a perspective view of the pouch container molded from the laminated tube.

Fig. 11 is a perspective view showing another example of the pouch  
5 container molded from the laminated tube.

Fig. 12 is a vertical section of the laminated tube in the sixth embodiment of this invention.

10 Fig. 13 is a partially cut, side elevational view of the laminated tube in the seventh embodiment of this invention.

Fig. 14 is a partially cut, side elevational view of the laminated tube in the eighth embodiment of this invention.

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Fig. 15(a) is a side elevational view, and Fig. 15(b) is a cross-sectional view, of the laminated tube in the ninth embodiment of this invention.

#### Preferred Embodiments of the Invention

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This invention is further described with respect to preferred embodiments, now referring to the drawings, in which Fig. 1(a) is a side elevational view, and Fig. 1(b) is a cross-sectional view, of the laminated tube  
25 in the first embodiment of this invention.

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As shown in Figs. 1(a) and 1(b), the laminated tube has a laminated structure in which the outer layer 3 having or consisting of a linear projecting  
30 portion 4 that extends in the axial direction is laminated onto the cylindrical substrate layer 2 that makes up the main body of the tube.

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The projecting portion 4 can be formed when the outer layer having or consisting of a linear projecting portion 3 is laminated onto only a part of the substrate layer 2. In addition, as shown in Fig. 2, the projecting portion 4 can also be formed by changing the thickness of the laminated outer layer 3 at one point of the cross-section.

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Fig. 3 is a sectional view showing schematically a system for the co-extrusion molding of the laminated tube 1. This system has die 11, which is connected to the first extruder and the second extruder (both of them now shown). The first extruder supplies the die 11 with a molten resin from which the substrate layer 2 is molded. The second extruder supplies the die 11 with another molten resin from which the outer layer 3 is molded.

The die 11 is connected to the first extruder by way of a circular path. A substrate layer resin path 13 is in a tubular shape and is connected to this circular path. An outer layer resin path 14 is disposed at one point on the periphery of the substrate layer resin path 13. This outer layer resin path 14 is connected to the second extruder by way of a resin discharge port 12. A mandrel 15 is disposed ahead of the exit of the die 11.

A molten resin is extruded by the first extruder, takes the shape of a tube in the circular path, and flows through the substrate layer resin path 13. Another molten resin is extruded by the second extruder, comes out of the resin discharge port 12, and flows into the outer layer resin path 14.

In the die 11, the molten resin coming from the outer layer resin path 14 adheres onto the surface of the tubular molten resin that flows through the substrate layer resin path 13. In this way, the outer layer 3 is adhered onto the surface of the tubular substrate layer 2 at a thickness that is uniform in the axial direction. Thus, a projecting portion 4 is formed on the substrate layer 2 by the outer layer 3, which is adhered to the substrate layer 2.

Consequently, the laminated tube 1 having the projecting portion 4 on the substrate layer 2 is extruded.

In Fig. 3, mandrel 15 stably retains the shape of the laminated tube 1 comprising the combined substrate layer 2 and the outer layer 3 having or consisting of a projecting portion 4 when the tube is pushed out of the die exit. The co-extrusion molding die also comprises a cooling system to cool down the laminated tube 1 that has been extruded from the molding die 11, a pulling system to pull the extruded laminated tube 1, and a cutting device to cut the laminated tube to a suitable length although these systems are not shown. The laminated tube 1 is manufactured after it passes through the processes using these systems.

At that time, a synthetic resin is suitably selected so that the substrate layer 2 to be formed has flexibility. On the other hand, another synthetic resin is selected so that the outer layer 3 is harder than the substrate layer 2.

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The co-extrusion molding process such as described above makes it possible to mold the laminated tube 1, in which the outer layer 3 having or  
5 consisting of the projecting portion 4, axially uniform in thickness, is laminated onto the substrate layer 2.

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The projecting portion 4 creates irregularity on the surface of the  
10 laminated tube 1. This irregularity improves the decorativeness and makes the tube 1 look attractive visually. If the substrate layer 2 and the outer layer 3 have different colors, the projecting portion 4 on the substrate layer 2 can be clearly identified by its color, thus resulting in improved designing.

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Since the projecting portion 4 can be identified simply by touch, it is easy to distinguish the laminated tube 1 from other tubes.

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20 Fig. 4 is a vertical section showing schematically a part of the molding die to mold the laminated tube by the cladding method. As shown in Fig. 4, the molten resin to be used as the outer layer 3 is pushed by the extruder from the resin discharge port (not shown) and flows into the outer layer resin flow path 14 in the die 11.

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The outer layer resin flows through the outer layer resin flow path 14 and comes out of the die exit where the diameter becomes much larger than the outer diameter of the tubular substrate layer 2. The circular die exit has a  
30 space at one point so that the projecting portion 4 is formed. The outer layer 3 is suctioned under reduced pressure in the direction shown by an arrow in Fig. 4. The already tubular main body 2 is supported by the mandrel 15, and the outer layer 3 is put in tight contact with the substrate layer 2. Thus, the substrate layer 2 is clad with the outer layer 3 having or consisting of the  
35 projecting portion 4 that is axially uniform in thickness.

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For example, a flexible aluminum laminating material can be used as the already tubular substrate layer 2. Then, the outer layer 3 may be made of

a synthetic resin material that is harder than the aluminum laminating material from which the substrate layer 2 is made.

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5           Thus, the cladding method can also be utilized to mold the laminated tube 1, in which the outer layer 3 having or consisting of the projecting portion 4, which extends axially, is laminated onto the substrate layer 2.

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10           In both of the co-extrusion molding method and the cladding method, the axially disposed projecting portion 4 has a uniform thickness. Unlike any surface defect, such a projecting portion 4 gives improved decorativeness to the laminated tube and is also capable of achieving a high-class image.

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By changing the shape of the exit of the die 11, it is possible to change the number, width, or shape of the projecting portion 4 on the laminated tube 1.

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Figs. 5 are (a) a side elevational view, and (b) a cross-sectional view, of the laminated tube 1 in the second embodiment of this invention wherein two projecting portions 4 are disposed axisymmetrically on the substrate layer 2.

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The two projecting portions 4 disposed axisymmetrically on the substrate layer 2 enable the laminated tube 1 to be pressed flat easily. The outer layer 3 having or consisting of a pair of the projecting portions 4 is made of a harder material than the substrate layer 2, which makes up the main body of the tube, and these projecting portions 4 serve as the backbone for the substrate layer 2 made of a flexible material. The laminated tube 1 is thus pressed flat and sealed to form a molded tube product, such as a tubular container or a pouch container made of this laminated tube 1.

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Fig. 6 shows a tubular container 9, one of the tube products, obtained by cutting the laminated tube 1 of Fig. 5 to a certain length, flattening and sealing one end of the tube, and fitting a head 8 to the tube by means of Thatcher method. This head 8 comprises shoulder 6 and neck 7. The tube portion of the tubular container 9 can be pressed flat, with the axisymmetrical

projecting portions 4 serving as the guide. Therefore, the contents inside the tubular container 9 can be discharged easily.

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5        Fig. 7 shows the laminated tube 1 in the third embodiment of this invention wherein the laminated tube 1 is provided with four projecting portions 4, which are disposed axisymmetrically. In this case, the laminated tube 1 of this embodiment is easily pressed flat because the groove portion 5  
10    outward.

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      When the projecting portions 4 are formed by the outer layer 3 laminated onto the substrate layer 2, a certain number of projecting portions 4  
15    can be designated for the specified contents to be filled in the tubular container 9 or later-described pouch container molded from the laminated tube 1. The user will be able to distinguish the contents inside the tube product, simply by touching the tubular or pouch container 9 or 10. Therefore, this feature is convenient especially for the blind. It is also convenient for the user with  
20    ordinary sight in using plural tubular or pouch containers 9 or 10 for different purposes.

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25       Fig. 8 shows the laminated tube 1 in the fourth embodiment of this invention wherein the outer layer 3 on the substrate layer 2 comprises the projecting portions 4 having different widths. Plural projecting portions 4 of different widths improve visual attractiveness of the tube, and wide projecting portions of the outer layer 3 can be used for printing.

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      Fig. 9 shows a tubular container 9 using the laminated tube 1 in the fifth embodiment of this invention, wherein the outer layer 3 laminated onto the substrate layer 2 consists of an even number of strip-like projecting portions 4 disposed in equal intervals. Under the configuration that an even  
35    number of projecting portions 4 are disposed in equal intervals on the substrate layer that makes up the main body of the tube, the laminated tube 1 has an up-and-down stripe pattern, which improves the decorativeness of the tube.

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Since the projecting portions 4 are disposed in an even number and in equal intervals, naturally there is an even number of grooves 5 between the projecting portions 4. In this configuration, the laminated tube 1 can be easily pressed flat, with the projecting portions 4 serving as the guide. This feature is convenient when the tubular container 9 or the pouch container 10 (See Fig. 10) is molded. Because the tubular container 9 or the pouch container 10 can be squeezed and pressed flat, using the projecting portions as the guide, the contents can be forced out smoothly from the tubular or pouch container 9 or 10, thus improving container handling.

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As shown in Figs. 10 and 11, the laminated tube 1 can be used to mold the pouch container 10. The laminated tube 1 is cut to a certain length, pressed flat and sealed at one end. Then, after the container has been filled with the contents, the other end is similarly pressed flat and sealed. There can be obtained a pouch container 10 with both ends being flattened in the same direction, as shown in Fig. 10, or there can be obtained another pouch container 11 with one end is in a direction orthogonal to the other end, as shown in Fig. 11.

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Fig. 12 is a vertical section of the laminated tube 1 in the sixth embodiment of this invention. As shown in Fig. 12, the laminated tube 1 comprises the substrate layer 2 that makes up the main body of the tube. In this embodiment, the outer layer 3 laminated onto the substrate layer 2 has or consists of the projecting portions 4, the thickness of which is changing in the axial direction. In the case of the co-extrusion molding method, the thickness of the outer layer 3 can be changed by changing periodically the extruding pressure for the outer layer 3. In the case of the cladding method, it can be changed by changing periodically the extent of suction under reduced pressure.

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The outer layer 3 having or consisting of the projecting portions 4 gives a graded effect caused by the change in the thickness. This gradation improves the decorativeness of the laminated tube 1.

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Fig. 13 shows the laminated tube 1 in the seventh embodiment of this invention, wherein the projecting portions 4 has a waveform pattern. In addition to the linear projecting portions, the waveform projecting portions 4

can be obtained by moving the die 11 from side to side at a certain stroke when the laminated tube 1 is molded. The waveform pattern improves the decorativeness and visual attractiveness of the laminated tube 1.

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Fig. 14 shows the laminated tube 1 in the eighth embodiment of this invention wherein spiral projecting portions 4 are formed. Not only the linear and waveform projecting portions, but also the spiral projecting portions 4 can be obtained by rotating the die 11 on its axis in a certain rotative direction  
10 when the laminated tube 1 is molded. The spiral pattern improves the decorativeness and visual attractiveness of the laminated tube 1.

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Fig. 15 shows the laminated tube 1 in the ninth embodiment of this  
15 invention wherein each projecting portion 4 has a different color. As shown in Fig. 15, the projecting portions 4 of different colors give the laminated tube 1 colorful stripe or waveform patterns, which improve decorativeness and designing of the laminated tube 1. Although Fig. 15 shows the projecting  
20 portions 4 in two colors that are alternately disposed, the pattern need not be limited to this embodiment. The projecting portions 4 in plural colors can be used, or each projecting portion 4 may have a different color. Plural colors can also be used at random for each projecting portion 4.

#### Effects of the Invention

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This invention comprising the above-described configuration has the following effects:

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In the invention of Claim 1, the outer layer having or consisting of a linear projecting portion in the axial direction is laminated onto the substrate layer that makes up the main body of the tube. The linear projecting portion on the outer surface of the tube gives the tube the decorative quality that makes the tube look attractive. It also becomes possible to distinguish the  
35 tube from other tubes simply by touch.

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In the invention of Claim 2, the outer layer to form a projecting portion is harder than the substrate layer, and is laminated onto the flexible substrate  
40 layer that makes up the main body of the tube. Therefore, this projecting

portion serves as the support to the main body of the tube, and maintains the form of the tube stably.

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5           In the invention of Claim 3, there is provided the outer layer that forms a linear projecting portion on the main body of the tube. The tube can be pressed flat easily along this projecting portion, which serves as the guide.

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10           In the invention of Claim 4, plural projecting portions are formed on the main body of the tube. These projecting portions improve decorativeness of the tube. When the projecting portions are formed by the outer layer laminated onto the substrate layer, a certain number of projecting portions can be designated for the specified contents with which the tubular container or the  
15           pouch container molded from the laminated tube is filled. From the number of the projecting portions, the user will be able to distinguish the contents, e.g., inside the tubular container, simply by touching the container. This feature is convenient especially for the blind. It is also convenient for the user with ordinary sight in using plural tubular containers for different purposes.

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          Since the projecting portions are disposed axisymmetrically in the invention of Claim 5, the tube can be pressed flat along the axisymmetrical projecting portions. The tubular containers or the pouch containers are  
25           molded easily by cutting the laminated tube to a certain length and sealing one end of the tube. Also when the contents are squeezed out of the tubular or pouch container, the projecting portions serve as the guide to press flat the tubular or pouch container. The contents, such as cream having certain viscosity, can be easily forced out of the tubular container or the pouch  
30           container, and the container handling is improved.

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          In the invention of Claim 6, the projecting portions with different widths are formed on the substrate layer that makes up the main body of the tube.  
35           These projecting portions improve decorativeness, and make the tube look attractive, and allow characters to be printed on the wide areas.

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          In the invention of Claim 7, the projecting portions are disposed at equal  
40           intervals on the substrate layer that makes up the main body of the tube.

Since a stripe pattern is formed over the entire tube surface, the tube shows improved decorativeness.

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5           In the invention of Claim 8, the outer layer is formed on the substrate layer, which makes up the main body of the tube, so as to give a graded effect caused by the change in the thickness of the projecting portions. The laminated tube has the improved decorativeness because of the gradation created by the projecting portions.

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          In the invention of Claim 9, the main body of the tube comprises an aluminum laminating material, and the outer layer having or consisting of a projecting portion or portions are laminated onto this material. The projecting  
15   portion or portions serve as the backbone and reinforce the aluminum laminated tube. Since the projecting portions are formed on the aluminum laminating material having a metallic silver color, the laminated tube has improved decorativeness, and shows a high-class image.

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          In the invention of Claim 10, the outer layer having or consisting of the projecting portions is laminated onto the substrate layer that makes up the main body of the tube. Not only surface irregularity but also additional colors improve the decorativeness because the outer layer has or consists of a  
25   projecting portion or portions in a different color or colors that make it easy to identify the tube clearly.

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          In the invention of Claim 11, there can be formed waveform projecting  
30   portions on the substrate layer that makes up the main body of the tube. In the invention of Claim 12, there can be formed spiral projecting portions. In addition to linear projecting portions, the projecting portions in various patterns formed on the substrate layer serve to improve decorativeness and visual attractiveness of the laminate tube.

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          In the invention of Claim 13, the decorativeness of the tube is improved because each projecting portion has a different color and because the projecting portions of attractive colors form a stripe or waveform pattern.

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In the invention of Claim 14 or 15, the laminated tube with added decorativeness can be used to mold an elaborately designed tubular container or pouch container.